

52036-62,041

**Work Order ID 53207**

Page 1

October 26, 2009 1:01:19 PM

Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *PL*Date: *09-10-26*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2221

Rev H

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221  
 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221  
 3- tack weld mesh on basket as per dwg D2221  
 A/R ER316 S.S. Rod Batch: *M10925*

*PD 09.11.03*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*PD 09/11/06*

# Work Order ID 53207

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Page 2

Item ID: D2221	Accept		Setup	Start	
Revision ID: H				Stop	
Item Name: 350 Basket Base					
Start Date: 26/10/2009	Start Qty: 1.00		Cust Item ID:		
Required Date: 04/11/2009	Req'd Qty: 1.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									

130	X pressure - wash	0.00							
	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel								
Powdercoat	M112140	0.00							
Powder Coating	Memo								

1- Plug holes prior to

1ST COAT: 8:45am  
 START TIME: 8:45am  
 OVEN TEMPERATURE: 400°F  
 FINISH TIME: 9:15am  
 \*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT: 9:30am  
 START TIME: 9:30am  
 OVEN TEMPERATURE: 400°F  
 FINISH TIME: 10:00am

# Work Order ID 53207

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Page 3

Item ID:	D2221	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	350 Basket Base					
Start Date:	26/10/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	04/11/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	QC3- Inspect Part Finish	0.00	UR	09-11-10		①			
QC Quality Control	Memo	0.00							
150 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

AND 53187 Per 11/11 ①

09/11/11 HJ

mf  
09-11-11

# Picklist Print

October 26, 2009 1:01:26 PM

Page 1

Work Order ID: 53207

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base



Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221-1RevH		Manufactured	No			100	Each	13.0000	1.0000			
												
Rib												



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1	
48101	1	
Main Warehouse		
WA	12	
51872	12	

PD 09.11.02

D2221-5RevH		Manufactured	No			100	Each	2.0000	2.0000			
												
Rib												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
50026	2	

53151x2 PD 09.11.02

D2221-7RevH		Manufactured	No			100	Each	5.0000	1.0000			
												
Rib												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	5	
51090	1	
51251	4	

PD 09.11.02

# Picklist Print

October 26, 2009 1:01:27 PM

Work Order ID: 53207



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-3RevC		Manufactured	No			100	Each	13.0000	2.0000			
Basket Hinge												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

13

50024

2

51870

11

PD 09.11.03

D2235-1RevB1

Manufactured

No

100

Each

20.0000

2.0000



Basket Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

7

51438

7

Main Warehouse

WA

13

50565

3

51871

10

PD 09.11.02

# Picklist Print

October 26, 2009 1:01:27 PM

Work Order ID: 53207

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base



Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	66.0000	2.0000			
												
Mounting Bracket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	13	
46086	2	
48428	1	
51120	10	
Main Warehouse		
WA	53	
50872	4	
51745	49	

D3442-1RevA

Manufactured No

100

Each

18.0000

2.0000



Shim



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1	
46767	1	
Main Warehouse		
WA	17	
50951	17	

2009.11.04

PD 09.11.03

# Picklist Print

October 26, 2009 1:01:27 PM

Work Order ID: 53207



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3825-041RevA		Manufactured	No			100	Each	8.0000	2.0000			

Rib Assembly (Basket End)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
51869	6	
Main Warehouse		
WA	2	
51171	2	

PD 09.11.02

D3826-041RevB

Manufactured No

100

Each

8.0000

2.0000



Rib / Gusset Assembly

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
51340	6	
Main Warehouse		
WA	2	
51088	2	

PD 09.11.02

# Picklist Print

October 26, 2009 1:01:27 PM

Work Order ID: 53207



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3827-041RevA		Manufactured	No			100	Each	5.0000	1.0000			

Rib Assembly (Inboard)

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

5

51339

5

100

Each

6.0000

1.0000

PD 09.11.02

D3832-1RevA

Manufactured

No



Mesh (Base)

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

2

46306

1

46774

1

Main Warehouse

WA

4

50942

1

51863

3

PD 09.11.03



# Picklist Print

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Work Order ID: 53207



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

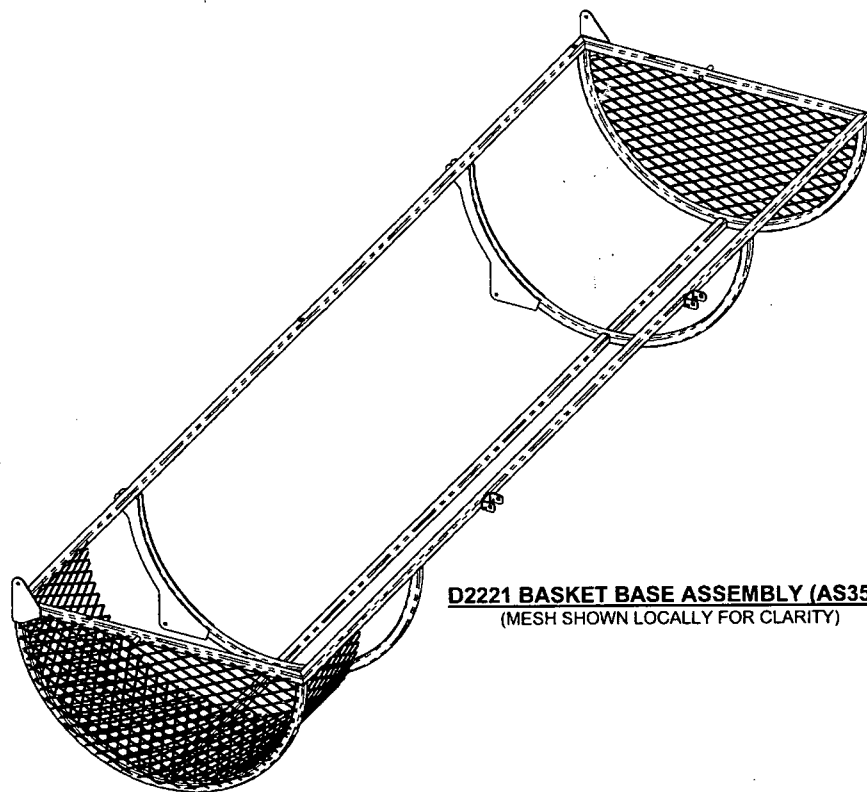
Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3833-1RevA		Manufactured	No			100	Each	10.0000	2.0000			
Mesh (Base End Face)												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8	
51304	8	
Main Warehouse		
WA	2	
50025	2	

PD 09.11.03



**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

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WORK ON  
NO. 53207

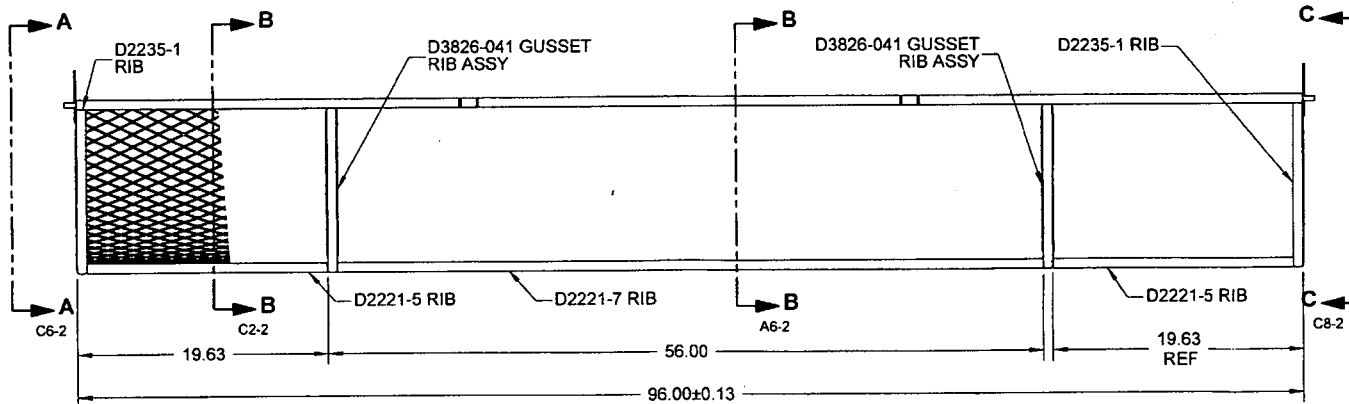
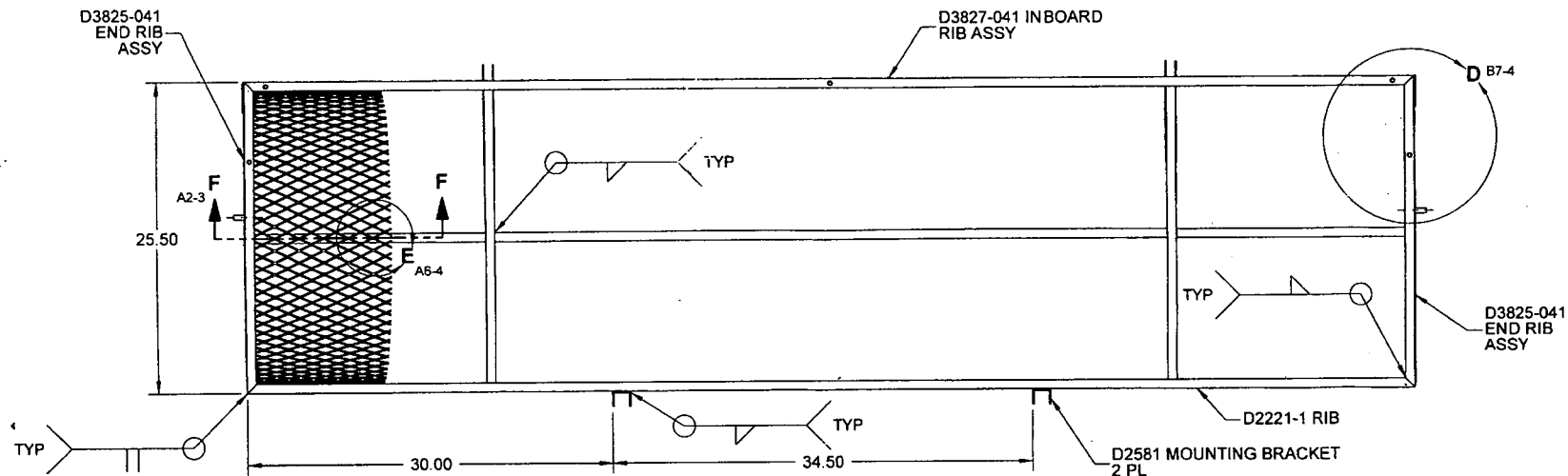
BS 09-10-24

RELEASED  
08/11/10

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5/7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 98.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BW		
CHECKED	BW	DRAWING NO.	REV. H
MFG. APPR.	BW	D2221	SHEET 1 OF 5
APPROVED	BW	TITLE	SCALE
DE APPR.	BW	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:  
MATERIAL: N/A  
FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
IDENTIFICATION: N/A  
WEIGHT: 42.00 lbs APPROX  
MASK ALL HOLES PRIOR TO POWDER COATING

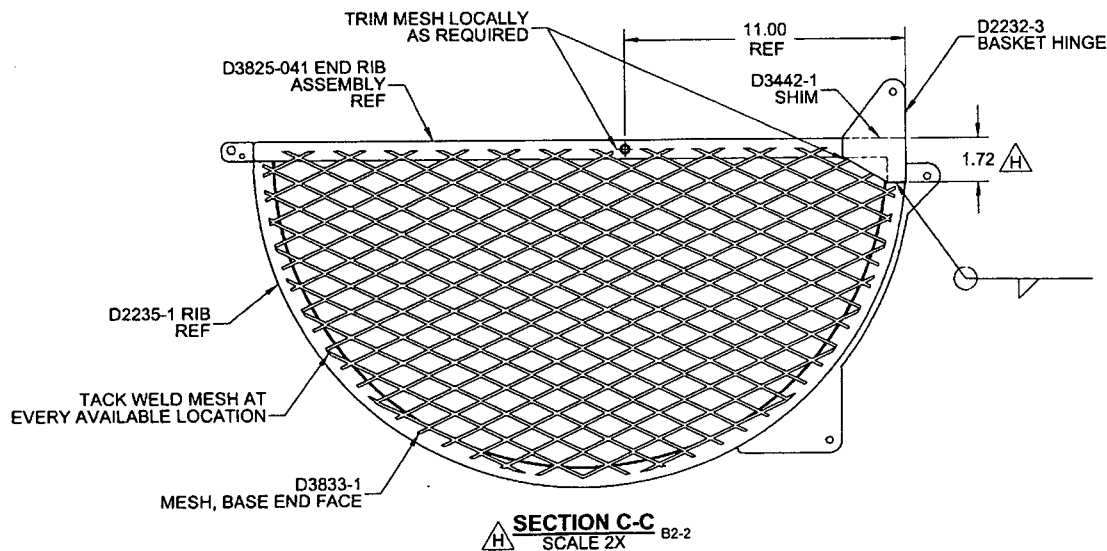
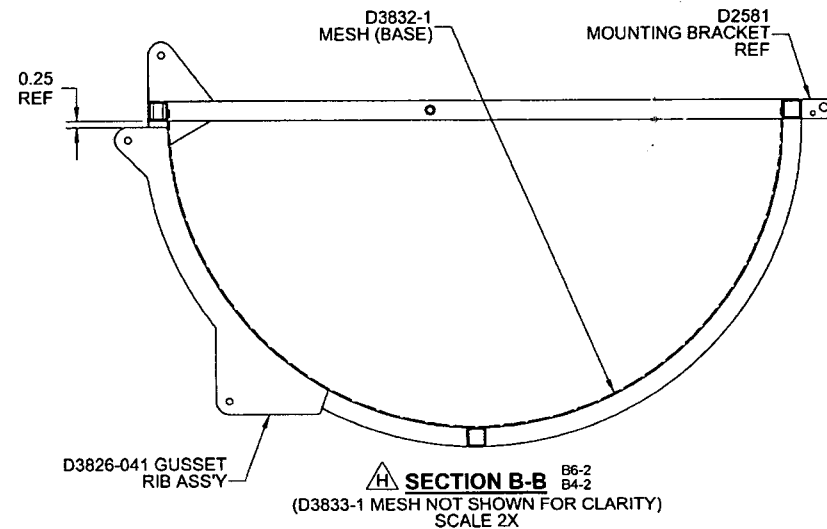
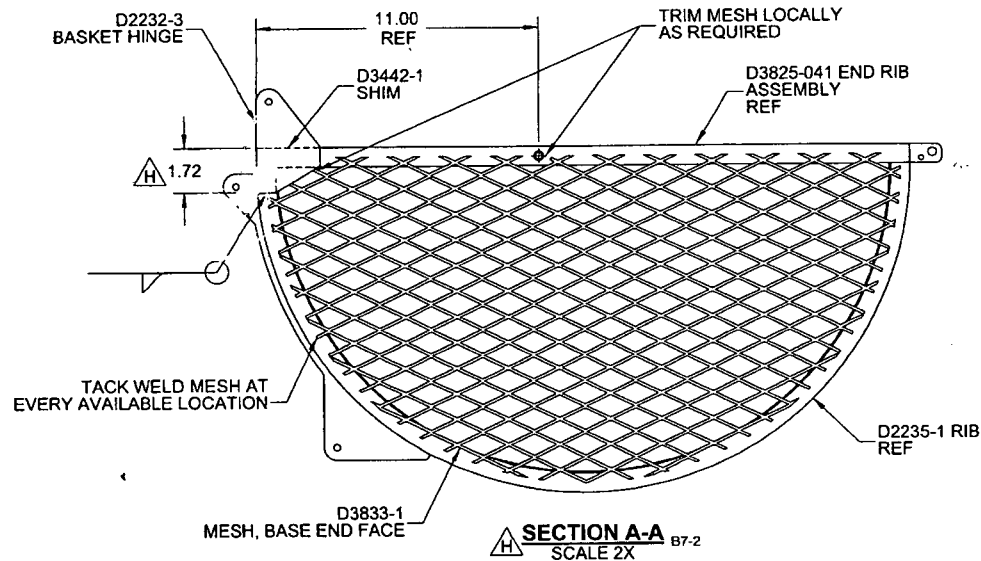


**D2221 BASKET BASE ASSEMBLY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

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06/11/18 MD

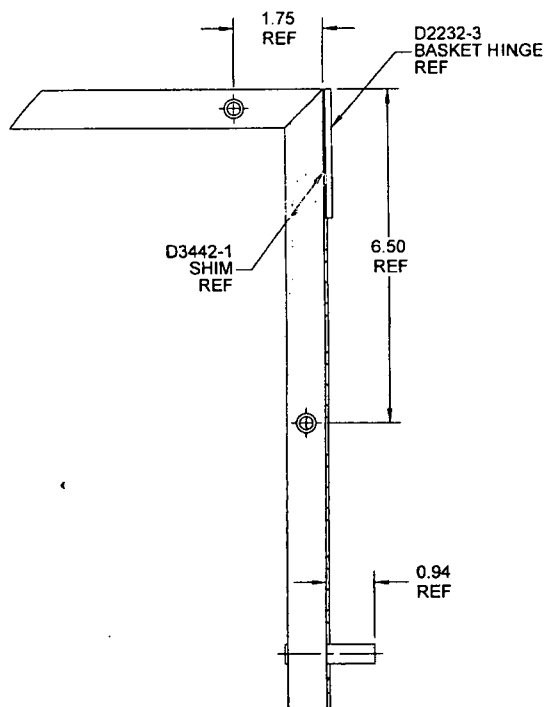
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D2221</b>	REV. H
MFG. APPR.	<i>[Signature]</i>		SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		<b>BASKET BASE ASSEMBLY (350)</b>	NTS
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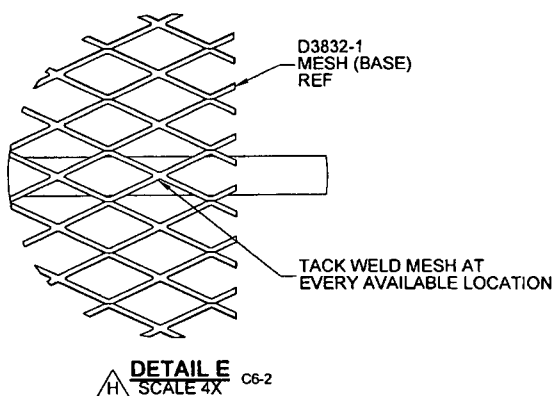
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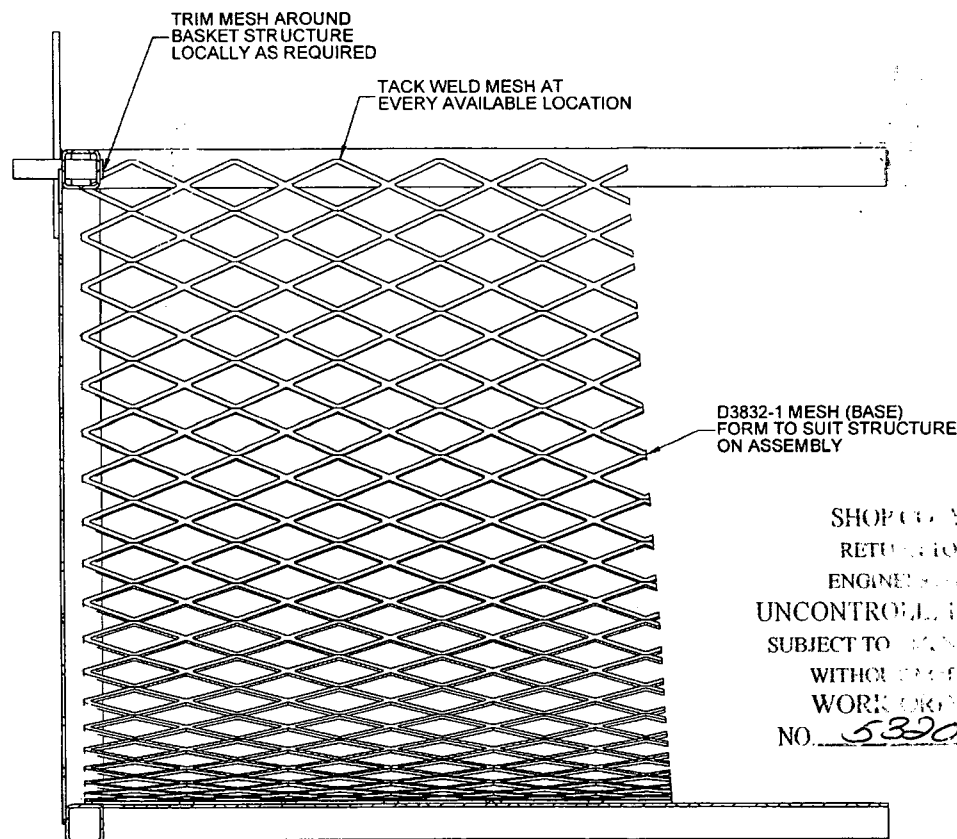
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DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	2	DRAWING NO.	REV. H
MFG. APPR.	1	D2221	SHEET 3 OF 5
APPROVED	1	TITLE	SCALE
DE APPR.	1	BASKET BASE ASSEMBLY (350) NTS	
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**DETAIL D**  
SCALE 4X D2-2



**DETAIL E**  
SCALE 4X C6-2

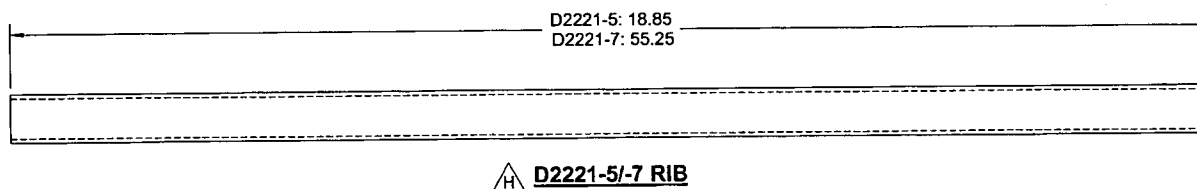
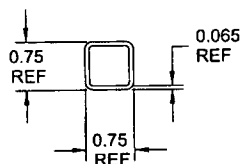
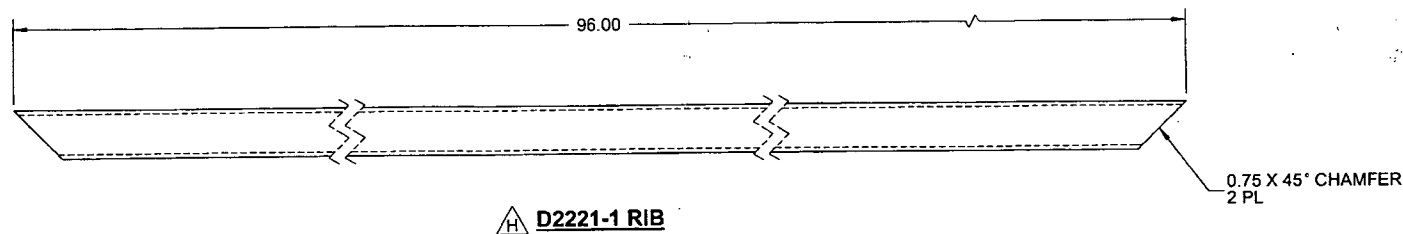
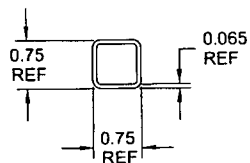


**SECTION F-F**  
SCALE 4X D7-2

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D2221	REV. H
MFG. APPR.	<i>[Signature]</i>		SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BASKET BASE ASSEMBLY (350) NTS</b>	
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08/11/16

NOTES:  
MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065  
FINISH: NONE  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
IDENTIFICATION: N/A  
WEIGHT: D2221-1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	MD	D2221	SHEET 5 OF 5
APPROVED	W	TITLE	SCALE
DE APPR.	SH	BASKET BASE ASSEMBLY (350) NTS	
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